

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001740**Date Inspected:** 16-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** u-rib deck panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and orthotropic box girders (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 deck plate u-rib	NA	NA	ZPMC QC MT

OBG Bay 1: ZPMC presented ZPMC Notification of witness inspection for magnetic particle testing of final weld DP083-001-012 at 1920 hours. Caltrans QA witnessed ZPMC QC perform magnetic particle (MT) on fillet weld, diaphragm plate joining u-rib, weld identified as 012. The ZPMC QC inspector is identified as Mr. Zhou Dongyan. Caltrans observed that the QC MT coverage was 100% and performed in conformance with the contract specifications. The following digital picture illustrates ZPMC MT inspection in progress.

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|---|------------------|----|----|-------|
| 2 | u-rib deck panel | NA | NA | QA VT |
|---|------------------|----|----|-------|
- OBG Bay 1: Caltrans QA Inspector performed visual inspection of the completed submerged arc welding (SAW) cover pass welds; partial joint penetration (PJP) welds joining the closed ribs to deck plate panel DP042-001, u-rib U150, welds 1 & 2; u-rib U138, weld 3 and DP003-001, u-rib U122, welds 9 & 10 and u-rib U145 weld 8. Caltrans QA observed welding overlap, over size welds, underfill and incomplete fusion. These indications observed at the weld were marked in yellow paint stick along the distance from the "Y" axis, starting at the weld start too weld completion end. The weld indications observed were recorded on Caltrans spreadsheet for future reference. The following digital pictures illustrate u-rib deck plate panel DP003-001.



### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer